

Date: Thursday, 2/14/2008 10:57:51 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW ASSEMBLY
 Job Number : 37436
 Estimate Number : 10758
 P.O. Number :
 This Issue : 2/14/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : THERMOFORMING
 Previous Run : 36581
 Written By :
 Checked & Approved By : 08 0214
 Comment : Est B 04.02.04 Reformat KJ/DS
 Est. C Thermoform in house 05/07/2007 DL
 Est D Rev E 07.09.28 EC verified by: DD

Part Number : D3136041
 Drawing Number : D3136 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 2/28/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS125 1/8" Polycast II Sheet



60



Comment: Qty.: 4.4625 sf(s)/Unit Total : 44.6250 sf(s)
 polycast II or plexiglass G .125"

107052 B 8-318 B 8-3-3

2.0 WATER JET B 8-3-3 FLOW WATER JET

E
B 8-318

12

Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-3-3

B 8-318 B 8-318



12

12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



10603-25 12



Comment: SECOND CHECK

5.0 THERMOFORMING THERMOFORMING MACHINE



Comment: 1-Thermoform as per Dwg D3136 and Folio FTA006

Dwg Rev. E

Folio Rev. B

D3108-9 B34554

2- Engrave Part # and Batch #, and affix labels
 (D3136-1)

B 08/03/10 X 12
 12 08/03/25 X 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:57:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 37436

Part Number: D3136041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



P.I.O.



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB

08/03/10 X12

Check product for scratches mal-formation or any other non conformance.

08/03/25 X12

7.0

QC8

SECOND CHECK



08/03/06 X12



→ P10

Comment: SECOND CHECK

08/03/11 X12

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

08/03/25

9.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part# Description Batch

34554

X24

2 D3108-9 Decal

34554

X24

08/03/25

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/26 X12

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2K5

Plastic WRAP.

08/03/26 X12

8/3/26 SP

(12X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



mf

08-03-27

U

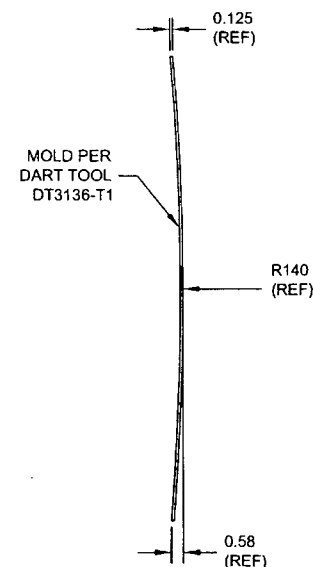
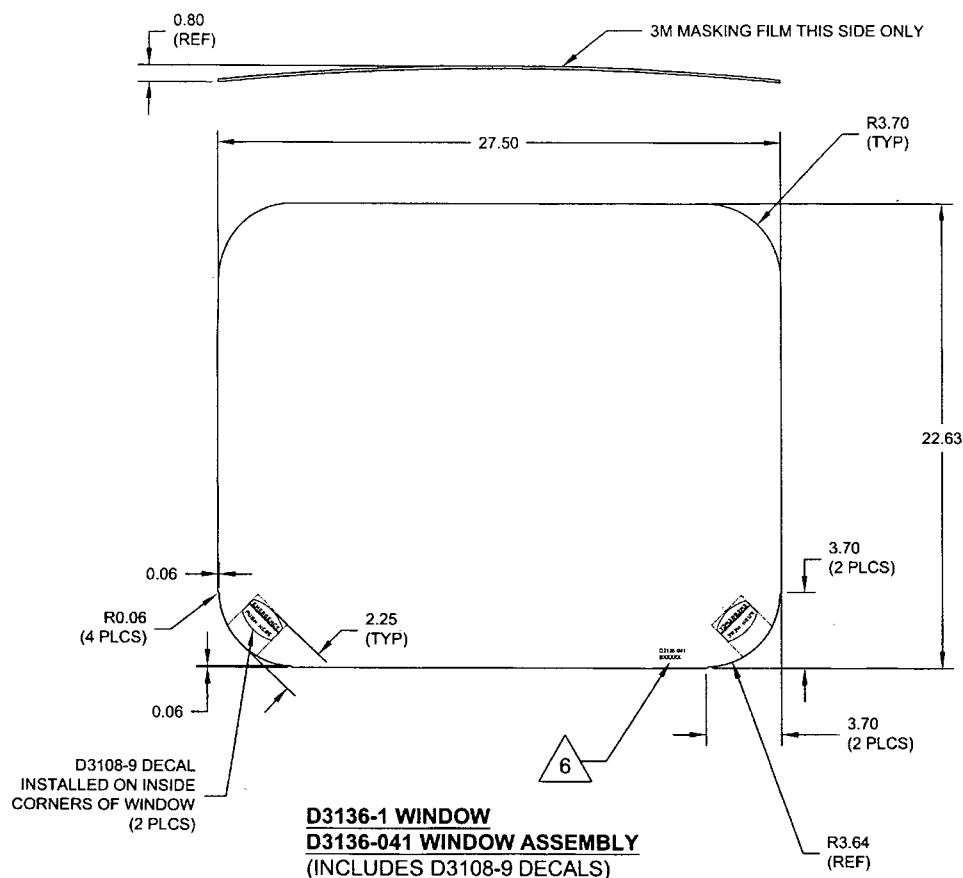
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136041 PAR #: N/A Fault Category: Red/Thermforming NCR: Yes No DQA: D Date: 08/03/27
D412 - 694 - 015/019 QA: N/C Closed: D Date: 08/03/28

NCR: <u>37436</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/10	60	OVER HEATED SHEETS IMPRINT OF CLOTH Surface onto windows.	<u>[Signature]</u>	Scrap all and replace. <u>(12)</u> <u>M 107252</u>	<u>Dr.</u> <u>08.03.18</u> <u>B</u> <u>8-3-26</u>	<u>[Signature]</u> <u>06.03.25</u>	<u>[Signature]</u> <u>04/04/2</u>	<u>[Signature]</u> <u>08/03/18</u>

NOTE: Date & initial all entries



RELEASED
01.09.22

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6

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NO. 3743

